

SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 32 Ra MAX MICROINCHES. OTHER SURFACES 125 Ra MAX MICROINCHES. ABRASIVE BLASTED SURFACES 60 TO 250 Ra MICROINCHES.  
 STUD STRAIGHT WITHIN .004 INCH PER INCH OF LENGTH.  
 PITCH DIA CONCENTRIC WITH BASE O.D. WITHIN .020 FIM.  
 PITCH DIA PERPENDICULAR TO BASE WITHIN  $\pm 1^\circ$ .

LENGTH L DATA (LENGTH CODE IN SIXTEENTHS OF AN INCH)

CODE	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32
L	.250	.375	.500	.625	.750	.875	1.000	1.125	1.250	1.375	1.500	1.625	1.750	1.875	2.000

MATERIAL AND FINISH DATA (NOTE: B SUFFIX TO PART NUMBER INDICATES ONE PIECE CONSTRUCTION REQUIRED)

CODE	MATERIAL	SPEC.	FINISH	SPEC.
A	2024 OR 7075 ALUMINUM	AMS-QQ-A-200, AMS-QQ-A-225, AMS-QQ-A-250	NONE	
AA			ANODIZE	MIL-A-8625 TYPE I, CLASS 1, NO SEAL
CR	302, 303, 304 OR A-286 CRES	AMS 5513, 5516, 5636, 5637, 5638, 5639, 5640, 5641, 5647 AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS 2700 METHOD 1, TYPE 8
CRA	A-286 CRES	AMS 5525, 5726, 5731, 5732, 5734, 5737 (CHEMISTRY ONLY)	PASSIVATE	AMS 2700 METHOD 1, TYPE 8
T	6AL-4V TITANIUM	AMS 4911, 4928, 4965, 4967	NONE	

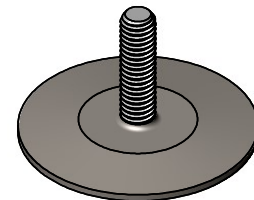
THREAD DATA

CODE	THREAD SIZE	$\phi \text{ TD}$
06	.1380-32 UNJC-3A	.1315 - .1340
08	.1640-32 UNJC-3A	.1570 - .1595
3	.1900-32 UNJF-3A	.1810 - .1840
4	.2500-28 UNJF-3A	.2410 - .2440
5	.3125-24 UNJF-3A	.3020 - .3060

OPTIONAL BASEPLATE PRIMER

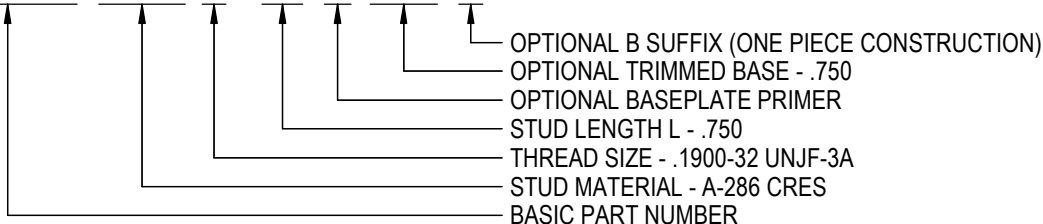
CODE	MATERIAL SPEC.
C	CYTEC BR127 PRIMER
P	MIL-PRF-85582 EPOXY PRIMER
W	CBPS-211 FILM PRIMER

MANUFACTURER'S OPTION:  
REDUCED MAJOR DIA TD



EXAMPLE PART NUMBER

**CB3000 CRA 3 - 12 P 750**



UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

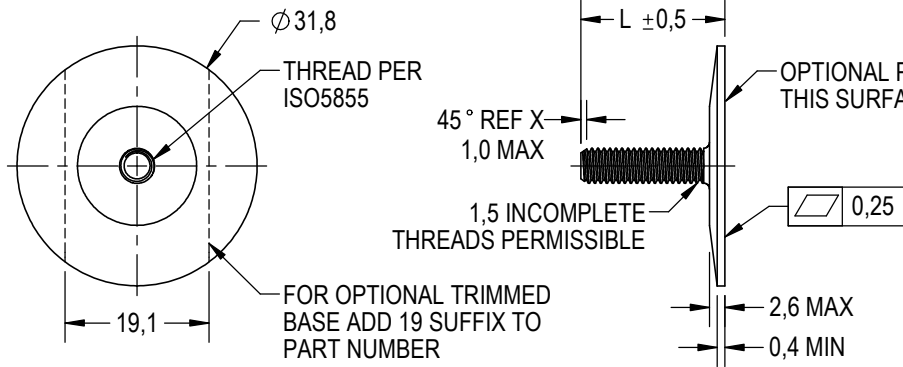
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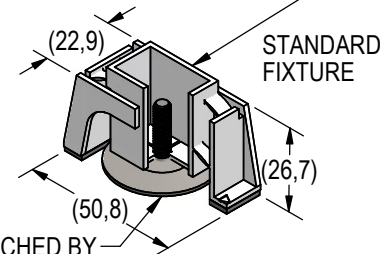
2151 LOCKHEED WAY  
CARSON CITY, NEVADA 89706

		APPROVALS	DATE
ANGLES	$\pm 1^\circ$	DRAWN <b>GTP</b>	25JUN20
.XX	$\pm .03$	CHECKED <i>DC Carter</i>	22JAN21
.XXX	$\pm .010$	RELEASED JLH	25JAN21
.XXXX	$\pm .001$	REVISED <b>GTP</b>	22JAN21

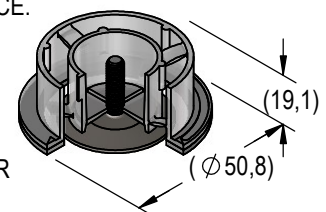
TITLE		DWG. NO.	REV.
STUD, ADHESIVE BONDED		CB3000	25
SIZE	CAGE CODE		
A	66530		
SCALE: 1:1		22JAN21	SHEET 1 OF 2



DISPOSABLE PRESSURE SENSITIVE ADHESIVE FIXTURE HOLDS STUD WHILE ADHESIVE CURES.



STUD ATTACHED BY ADHESIVE APPLIED TO THIS SURFACE.



FOR OPTIONAL ROUND FIXTURE ADD R SUFFIX TO PART NUMBER

SURFACE TEXTURE: ROOT RADIUS AND THREAD FLANKS 0,8 Ra MAX MICROMETERS. OTHER SURFACES 3,2 Ra MAX MICROMETERS. ABRASIVE BLASTED SURFACES 1,5 TO 6,3 Ra MICROMETERS. STUD STRAIGHT WITHIN 0,004 mm PER mm OF LENGTH. PITCH DIA CONCENTRIC WITH BASE O.D. WITHIN 0,5 FIM. PITCH DIA PERPENDICULAR TO BASE WITHIN ±1°.

LENGTH L DATA (LENGTH CODE IN MILLIMETERS)

CODE	6M	8M	10M	12M	15M	20M	25M	30M	35M
L	6	8	10	12	15	20	25	30	35

MATERIAL AND FINISH DATA (NOTE: B SUFFIX TO PART NUMBER INDICATES ONE PIECE CONSTRUCTION REQUIRED)

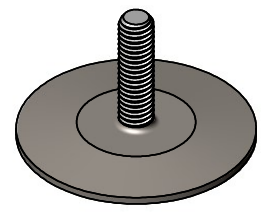
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AA	ALUMINUM		ANODIZE	MIL-A-8625 TYPE I, CLASS 1, NO SEAL
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T	6AL-4V TITANIUM	AMS 4911, 4928, 4965, 4967	NONE	

THREAD DATA

CODE	THREAD SIZE
3M	MJ3 X 0,5 4h6h
4M	MJ4 X 0,7 4h6h
5M	MJ5 X 0,8 4h6h
6M	MJ6 X 1,0 4h6h
8M	MJ8 X 1,0 4h6h

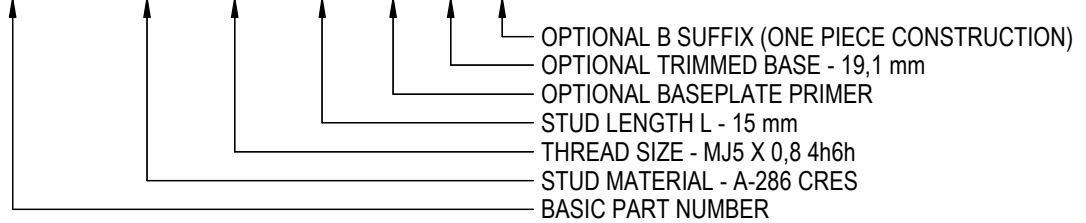
OPTIONAL BASEPLATE PRIMER

CODE	MATERIAL SPEC.
C	CYTEC BR127 PRIMER
P	MIL-PRF-85582 EPOXY PRIMER
W	CBPS-211 FILM PRIMER



EXAMPLE PART NUMBER

**CB3000 CRA 5M 15M P 19**



UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN MILLIMETERS AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

METRIC DIMENSIONS	
ANGLES	±1°
.X	±0,8
.XX	±0,25

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APPROVALS		DATE
DRAWN	<b>GTP</b>	25JUN20
CHECKED	<i>DC Carter</i>	22JAN21
RELEASED	JLH	25JAN21
REVISED	<b>GTP</b>	22JAN21

**CLICK BOND**

SIZE **A** CAGE CODE **66530**

SCALE: 1:1

2151 LOCKHEED WAY  
CARSON CITY, NEVADA 89706

TITLE **STUD, ADHESIVE BONDED**

DWG. NO. **CB3000 (METRIC)** REV. **25**

22JAN21 SHEET 2 OF 2